123429

Page 1

Insp.

Stamp

Thursday, August 07, 2014 11:15:23 AM Accept Item ID: D3391-023 *N900040100* Setup Start **Revision ID: Item Name:** Mid Tube Assembly *1* **Start Qty:** 1.00 **Start Date:** 7/29/14 **Cust Item ID:** Required Date: 8/07/14 Req'd Oty: 1.00 **Customer:** Reference: Run Start Date: 14-08 Of Tooling: Process Plan: ML 3 **Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Operation Set Up/ **Tool ID** Tool # Plan Reject Reject Sequence ID/ Accept Description : 1 **Work Center ID Run Hours** Code Oty Oty Number **Draw Nbr Revision Nbr** D3391 I 100 0.00 Skidtubes *100* 0.00 Skidtubes Memo 1-Cut tube to finish length as per Dwg D3391 Skidtubes 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391 3-Open saddles and GHW holes to Ø0.375" exept for fwd saddle hole of detail 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391 6-Deburr 7-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker. ***DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG 8-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (10 holes) as per Dwg D3391 SE14-09-03 9-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391 ***DO NOT OPEN 2 MOST FWD WEARPLATE HOLES***

DQA:	dut_	Date:	14(1	2/11								JARK
QA Closed:	3A0	Dato	14/1	71	WORK ORDER NON	I-CC	ONFO	RMANCE / UI		ork Order up	ndate only	AEROSPACE
QA Glosed.Z		Date.		4								
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Part N	o. <u>D3=</u>	391-		3	Rework 📈 Scrap Use-as-is Suspected Unapproved)		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	=1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
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Root	Date	Štep	Qty	Desci	ription of work order update or non-conformance		Initial iief Eng	Act	ion iption	Sign & Date	Verification	QC Inspector
Cause	Date	Steb	Qty	<	Il spot Foce on aft	101	ner Eng	Desci	рион	Date	Vermeation	QC IIISPECTOI
Design Doc/Data Equip/Tooling Handling/Pre Material	14-9-3	14-9-3 100 1 Bottom			ton end 1.06" from ater went to dilla mobile bale that slow be there, but wells refue going throught		248 12 89	Acceptable In region	Cheve	DAS 7 12 9-89	H-9-3	1418/05
Operator Offset/Setup Process Supplier	M			ral it b	refue going throught over such	9/1	Acceptable In region where 14/4/3 * welding is acceptable per			14/4/3 AlR M125127	H-9-	
Training Transport										BE 14-09-02		
Unapproved		<u> </u>	L	<u> </u>		ΕΛ	III T CV.	TEGORY		<u> </u>		<u> </u>
Landin	ng Gear	***			General	10	OLI CA	TEGOW!				`
	Bending				Bend		4	Program		Outside Dim	}	Pressure/Forced
	Centre No	ot Concer	ntric	_	BOM/Route		Grain		ļ	Over/Under	<u> </u>	Set-up
	Cracks				Broken/Damage/Defect	\vdash	Hardwa		-	Part Incorre		Temperature/Cure
	Crimp/Ki	nk/Ripple	/Wave				4 '	ion Incomplete/U	_	Part Lost/M	· -	Weld
	 1	Counterpart Counte			-	-	4	tions Incomplete/l	Unclear	Part Moved	<u></u>	Wrong Stock Pulled
	Crushing				Countersink	\vdash	- '	gned/off center		Positioned \ Power Loss/		Other
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	 1 '				Finish	\vdash	-					
	Turning Sequence Wave/Twist in Tube				Fit/Function	Out of Calibration Out of Sequence						

Thursday, August 07, 2	2014 11:15:23 AM							**
Item ID: D339: Revision ID: Item Name: Mid To	1-023 ube Assembly		Accept	*N900	04010	// *	Setup Sta	10'21
Start Date: 7/29/1 Required Date: 8/07/1	4 Start Qty: 1.00	•		Cust Item l Customer:	ID:			14.32 ¢
Reference:		•					_	
Approvals: Proc	ess Plan:	Date:	Tooling:	D :	ate:	_	Run Sta	"NHI"
QC:		Date:	SPC (Y/N):	D:	ate:	70786	Sto	" *NR2*
Sequence ID/ Work Center ID		• •	Set Up/ Run Hours *do not open fwd saddle holes -023 at 9.00" (see view z-z)	Tool ID *** BRIGHT	Tool # Plan Code	_	Reject Qty	Reject Insp. Number Stamp
	remaining dia hole, tranfer dr D3391-02	g fwd saddle holes usin using t-pins and clicos illed pilot holes in D33 21 BATCH:	e hole only to .188" dia, transfeg DT 8149 locating from previto ensure perfect allingment, op 91-023/-021 to 0.438" dia. in 12.3.2	usly drill 188" pen up previosly 03391-021				
	wearplate	holes into D3391-021	plate holes in D3391-023 drill		/ N		<i>f</i>	
	15- Open	10 wearplate holes in	D3391-021 to 0.297" dia.) 1	Y 19	-//-	5
	. 16- insert	t D3391-021 into D339	11-23					
	17- insert	t T-pins into first and tl	nird fwd saddle holes					3 1.
•	18- ON F as per	FIRST SIDE ONLY dri	ll out 2nd and forth fwd saddle:	s holes to 0.500"	<i>/</i>			
	10 ON 0	ND CIDE ONLY	and Ond and family additionals.	a 0 400"		•		

20-Deburr and blow out all chips from inside tube, scribe batch # in D3391-923

DQA:			Date:										"DART		
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				1		AEROSPACE
QA Closed:			Date:								vork C	raer up	date only		<u></u>
Work Orde	or.					DISPOSITION				AGAINST D	EPAR'	TMENT	PROCESS		
WOIK OIG	٠					Rework	ıl		Skid-tube	Crosstube		•	Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	7	Pro	d. Eng. Coor.		Quality
	•					Use-as-is	1	Thern	noforming	Finishing	F	Rec/Stor	e/Packaging		Other
NCR N	۱o.					Suspected Unapproved			Large Fab	Composite			Supplier		
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Root					Desc	ription of work order update	1	nitial	Acti		- 1	gn &			001
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	1-1	Date	Verificatio	<u>n</u>	QC Inspector
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		Cracks				Broken/Damage/Defect		Hardwa	are		Part	t Incorre	ci		Temperature/Cure
		Crimp/Kit	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part	t Lost/Mi	issing	L	Weld
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		Heat Trea	at			Cut Too Short		Mislabeled			Pow	ver Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misread							
		Marks/Ch	natter			Drill Holes		Off-set							
		Turning S				Finish		4	Calibration						
	Wave/Twist in Tube			ре		Fit/Function		Out of	Sequence		5				

Work Order ID 123429

123429

Page 3

Thursday, August 07, 2014 11:15:23 AM

D3391-023 Item ID: **Revision ID:**

Accept

N900040100

Setup Start

Stop

Item Name:

Mid Tube Assembly

Start Date:

Required Date: 8/07/14

7/29/14

Start Qty: 1.00 **Req'd Qty:** 1.00

1 *1*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: OC:

Date: _____

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop

Sequence ID/ **Work Center ID** Operation **Description**

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Run

Reject Qty

Reject Insp. Number Stamp

110

110 QC

0.00 DAS 16 0.00 9-89

Idlulia

Quality Control

120

120

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

Memo

0.00

130

QC7-Inspect Chemical Conversion Coat

0.00

130 QC

Quality Control

Memo

0.00

DQA:			Date:											TRAC"		
						WORK ORDER NON	-CC	ONFO	RMANCE / UP				AEROSP.	ACE		
QA Closed:			Date:							V	Vork Order u	pdate only				
Work Orde	ır.					DISPOSITION				AGAINST D	EPARTMEN'	r/PROCESS				
WOIK Olde	٠.			·	<u> </u>	Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering			
Part N	lo.					Scrap	┪ ┃		Machining	Small Fab	Pr	od. Eng. Coor.	Quality	7		
	•					Use-as-is	1		noforming	Finishing	Rec/Sto	ore/Packaging	Other			
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		Bending	- + C		\vdash	Bend BOM/Route	-	Grain	riograffi	-		r tolerance	Set-up	•		
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		Marks/Ch			-	Drill Holes	<u> </u>	Off-set								
		l '				Finish		Out of Calibration								
	Turning Sequence Wave/Twist in Tube				Fit/Function		Out of									

Work	Order	· ID	123429
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Page 4

Thursday, August 07, 2014 11:15:23 AM Accept D3391-023 Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Mid Tube Assembly *1* 7/29/14 **Start Qty:** 1.00 **Cust Item ID: Start Date:** Req'd Qty: 1.00 Required Date: 8/07/14 *1* **Customer:** Reference: Run **Tooling:** Process Plan: Date: Date: Approvals: Stop SPC (Y/N): Date: QC: Date: Reject Reject Operation Set Up/ Tool ID Tool # Plan Accept Insp. Sequence ID/ Number Stamp **Work Center ID Description Run Hours** Code **Qty** Qty 140 0.00 Skidtubes *140* Skidtubes Memo 1-Open float bag holes as per dwg Skidtubes 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: 15-6-7 batch#: /30227 NOTE: ENSURE WEB IS INSERTED IN AFT END OF TUBE 150 QC5- Inspect part completeness to step on W/O 0.00 1 8 14-11-1 *150*

OC

Memo

0.00

Quality Control

DQA:			Date:													
						WORK ORDER NON-CONFORMANCE / UPDATE								EROSPACE		
QA Closed:			Date:							W	ork Order up	date only	_]			
Work Orde	ır.					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS				
·	•		•			Rework	7		Skid-tube	Crosstube	7	Water Jet	Engin	eering		
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.		Quality		
	•	-				Use-as-is	1		noforming	Finishing	Rec/Stor	e/Packaging	7	Other		
NCR N	lo.					Suspected Unapproved]		Large Fab	Composite]	Supplier				
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Root		_	_		Desc	ription of work order update		nitial	Acti		Sign &			l.,		
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		Bending				Bend	<u> </u>	4 `	Program		Outside Dim			e/Forced		
.*		Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain			Over/Under		Set-up			
		Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		_	Part Incorre		⊣ '	ature/Cure		
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs	-	4	tion Incomplete/Un		Part Lost/Mi	issing	Weld	Secret Bullion		
		Cuffs			\vdash	Contamination		4	tions Incomplete/U	Inclear	Part Moved		wrong:	Stock Pulled		
		Crushing			ļ	Countersink	1	-1	gned/off center	 	Positioned V		Tokke:			
	-	Heat Trea				Cut Too Short	-	Mislab		L_	Power Loss/	ourge [Other	1100		
	_	Inspectio		lube	<u> </u>	Drawing	-	Misread						***		
		Marks/Ch			\vdash	Drill Holes	\vdash	Off-set								
		Turning Sequence Finish Wave/Twist in Tube Fit/Function				Out of Calibration Out of Sequence					 					
		į vvave/ i w	vist in Tub	e e		Fit/Function		Jour of	sequence							

Work Order ID 123429

123429

Page 5

Thursday, Augu	st 07, 2014 1	1:15:23 AM			.74/9						
Item ID: Revision ID: Item Name:	D3391-023 Mid Tube As	•		Accept	*N900		100	* S	Setup Sta	171	S1* S2*
Start Date: Required Date: Reference:	7/29/14 : 8/07/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:			,	_		
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:		R	tun Sta Sto	" " []	R1* R <i>2</i> *
Sequence ID/ Work Center I 160 *1 60* Skidtubes Skidtubes	D	Operation Description Skidtubes Memo 1-Weld cross 2-grind weld	sbolt spacer as per dwg Dû I flush	Set Up/ Run Hours 0.00 0.00 3391 & QSI 004	Tool ID Al MI29285	Tool#		Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control		QC10- Inspect visual per Memo	· QS1004- ground welds	0.00			<u>.</u>	-			DAS 38 9-89 14-//-/1
180 *1 AN* QC Quality Control		QC5- Inspect part compl	leteness to step on W/O	0.00			-				DAS 38 9-89

DQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE							
QA Closed:		Date:			WORK ORDER NON-	-CC	JNFOI	RIVIANCE / UPDA		ork Order up	date only	AEROSPACE
Work Orde	; ·				DISPOSITION			А	GAINST DE	PARTMENT/	PROCESS	
Part N					Rework Scrap Use-as-is			Machining Sr	osstube mall Fab inishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	o. <u> </u>		· · · · · · · · · · · · · · · · · · ·		Suspected Unapproved]	Large Fab Cor	mposite		Supplier	
Root		·		Desci	ription of work order update	i	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector
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Material	7	ye.										
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Landin	g Gear				General			· · · · · · · · · · · · · · · · · · ·				
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[Centre N	lot Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
Ì	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ci	Temperature/Cure
Ī	Crimp/Ki	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unquali	ified	Part Lost/Mi	ssing	Weld
Ī	Cuffs				Contamination		Instruc	tions Incomplete/Unclea	ar	Part Moved		Wrong Stock Pulled
ļ	Crushing	;			Countersink		Misali	gned/off center		Positioned V	Vrong	
ļ	Heat Treat Cut Too Short				Mislabeled Power Loss/Surge					Surge	Other	
ļ	_				Drawing	Misread						
ļ					Drill Holes		Off-set					
ţ			!		Finish		4	Calibration				
ľ	Turning Sequence Wave/Twist in Tube				Fit/Function							

Quality Control

Thursday, August 07, 2014 11:15:23 AM

123429

Page 6

D3391-023 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Mid Tube Assembly *1* Start Qty: 1.00 7/29/14 **Start Date: Cust Item ID:** Required Date: 8/07/14 Req'd Qty: 1.00 *1* **Customer:** Reference: Run Start Process Plan: Date: Tooling: **Approvals:** Date: Stop Date:_ SPC (Y/N): Date: QC: Sequence ID/ Tool ID Reject Reject Operation Set Up/ Insp. Tool # Plan Accept Number Stamp Qty **Work Center ID Run Hours** Code Qty Description Pressure Wash per QSI005 4.3 185 0.00 *125* HandFinish 0.00 Memo Hand Finishing AND REALODINE AS PER PAR09-043 \$ 14-11-13 to \$ White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00 190 *190* 0.00 Powdercoat Powder Coating 200 QC3- Inspect Part Finish 0.00 0.00 QC Memo

DAS 15

WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:	
Work Order: Part No. NCR No. DISPOSITION Rework Scrap Use-as-is Suspected Unapproved Suspected Unapproved DISPOSITION Rework Skid-tube Skid-tube Machining Small Fab Prod. Eng. Coor. Rec/Store/Packaging Supplier Other Supplier	
Work Order: Rework	
Part No. Scrap Use-as-is NCR No. Suspected Unapproved Skid-tube Crosstube Prod. Engineering Small Fab Prod. Eng. Coor. Large Fab Composite Supplier Supplier	
Part No. Scrap Use-as-is NCR No. Suspected Unapproved Suspected Unapproved Suspected Unapproved NCR No. Suspected Unapproved Suspected Unapproved Suspected Unapproved NCR No.	
NCR No. Use-as-is Use-as-is Thermoforming Finishing Rec/Store/Packaging Other Supplier	
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Root Description of work order update Initial Action Sign &	
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspe	ector_
Design Design	
Doc/Data Doc/Data	
Equip/Tooling	
Handling/Pre	
Material	
Operator	
Offset/Setup Offset/Setup	
Process Process	
Supplier Sup	
Training	
Transport	
Unapproved	
FAULT CATEGORY	•
Landing Gear General Bending Bend Folio/Program Outside Dimensions Pressure/For	cod
	Leu
	/Cure
	/ care
Crimp/kink/kippie/wave Burrs Inspection incomplete/oriqualities Part Loss/ winssing Wrang Stock	Pulled
Crushing Contamination Instructions incomplete/Unclear Part Moved Wrong Misaligned/off center Positioned Wrong	
Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other	
Inspection Strip in Tube Drawing Misread	
Marks/Chatter Drill Holes Off-set	
Turning Sequence Finish Out of Calibration	
Wave/Twist in Tube Fit/Function Out of Sequence	

Work Orde						Page 7						
Item ID: Revision ID: Item Name:	D3391-023 Mid Tube Ass	sembly		Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: 7/29/14 Start Qty: 1.00 Required Date: 8/07/14 Req'd Qty: 1.00 Reference: Approvals: Process Plan:			*1* *1*		Cust Item I Customer:	D:						
			Date:	Tooling: Date:						Start Stop		R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
230 HandFinish Hand Finishing	_	HandFinishing Memo 1- press fit l	D3591-1 spacers using D1	0.00 19416 starting from 0.500'	' side			l x		4	· <u>IL</u>	141016.
240		2-Install Ins QC5- Inspect part comp	erts as per Dwg	0.00	- -			1	****	_		DAS 38
* 240 *		Memo	•	0.00					-			9-89 14-12-

250

Identify as per dwg & Stock Location: Wb

0.00 D412-742-043/B126410 1x & Al 14/11/05

250 Packaging

Quality Control

Memo

0.00

Packaging

DQA:	·	Date:											TAAG*	
					WORK ORDER NON-	-CC	ONFO	RMANCE / UF			0.1	,		AEROSPACE
QA Closed:		Date:								work	Order up	date only		
Work Orde	r.			:	DISPOSITION				AGAINST	DEPA	RTMENT	PROCESS		
WOIR OIGE					Rework		ı	Skid-tube	Crosstube			Water Jet	7	Engineering
Part N	0.				Scrap		I I		Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is			noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite			Supplier		
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Landir	ng Gear			_	General		•		,			г	 -1	
	Bending				Bend	L	•	Program		_	ıtside Dim	F	_	ressure/Forced
	Centre No	ot Conce	ntric		BOM/Route	L	Grain			_	•	tolerance	—	et-up
	Cracks			_	Broken/Damage/Defect	_	Hardwa			—	rt Incorre	<u> </u>		emperature/Cure
·	Crimp/Kir	nk/Ripple	e/Wave		Burrs		Inspection Incomplete/Unqualified			—	rt Lost/Mi	ssing	—	/eld
	Cuffs			<u> </u>	Contamination		4	tions Incomplete/U	Jnclear	-	rt Moved	L	\~	rong Stock Pulled
	Crushing			<u> </u>	Countersink		4	gned/off center		\blacksquare	sitioned V	- r		
	Heat Trea			<u> </u>	Cut Too Short		Mislabeled			Po	wer Loss/	Surge [0	ther
ļ	Inspectio		Tube		Drawing		Misread							
:	Marks/Ch				Drill Holes	<u></u>	Off-set					 -		
	Turning Sequence Finish			4	Out of Calibration									
	Wave/Twist in Tube				Fit/Function		Out of Sequence							

Work Ord Thursday, Augu					Page 8								
Item ID: Revision ID:	D3391-023			Accept	*N900	040	100)*	Setup	Start	171.	S1*	
Item Name:	Mid Tube A	ssembly								Stop	*N:	S2*	
Start Date:	7/29/14	Start Qty: 1.00	*1*		Cust Item I	D:							
Required Date: 8/07/14 Req'd Qty: 1.00		*1*		Customer:									
Reference:			•										
Approvals:	Process P	lan:	Date:	Tooling:	Da	ate:	-		Run	Start	*NI	R1*	
QC:		Date:	_ SPC (Y/N):	Da	ate:				Stop	*NI	R2*		
Sequence ID/ Work Center	TD .	Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

260

260

Quality-Control.

APIH-12-09

DQA:	Date:											T		
WORK ORDER NON-CONFORMANCE / UPDATE												AEROSPA	CE	
QA Closed:			Date:					t			ork Order up	date only		
Work Orde	r.					DISPOSITION								
Work Orac	' · -		-			Rework			Skid-tube	Crosstube		Water Jet	Engineering	7
Part N	ο.					Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	1	
	-		-	· · · · ·		Use-as-نِه		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	o					Suspected Unapproved			Large Fab	Composite		Supplier		
Root	1				Desc	ription of work order update		nitial	Acti	on	Sign &	r		
Cause	1	Date	Step	Qty	Desc	or non-conformance		ief Eng			Date	Verification	QC Inspecto	r
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Landin						General	_	1	_	r	7	. г	一。 / , ,	
	-	Bending			<u> </u>	Bend	L	1	Program	<u> </u>	Outside Dim		Pressure/Forced	
		Centre No	ot Concer	ntric	\vdash	BOM/Route	<u> </u>	Grain		-	Over/Under		Set-up	
	\neg	Cracks			<u> </u>	Broken/Damage/Defect	<u></u>	Hardwa		<u> </u>	Part Incorre	F	Temperature/Cu	re
	Crimp/Kink/Ripple/Wave					Burrs		ł '	ion Incomplete/Un	<u> </u>	Part Lost/M	-	Weld	امط
	Cuffs					Contamination	\vdash	-	tions Incomplete/U	Inclear.	Part Moved	L-	Wrong Stock Pul	eu
	Crushing				<u> </u>	Countersink	<u> </u>	₹ '	gned/off center		Positioned V		Other	
	Heat Treat Inspection Strip in Tube					Cut Too Short	-	Mislab		L	Power Loss/	ourge [Tottler	
-	-		•	ıupe		Drawing	\vdash	Misrea Off-set						
	-	Marks/Ch			-	Drill Holes	-	- ·	Calibration					,
	_	Turning S Wave/Tw			\vdash	Finish Fit/Function	\vdash	4	Calibration Sequence					
L 1		vvave/ IW	nst in Tub	Je		ILITA FULLCUOII	.l	Jour of	sequence					

Picklist Print

Thursday, August 07, 2014 11:15:22 AM

Work Order ID: 123429

123429

Parent Item:

D3391-023

D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 7/29/14

Required Date: 8/07/14

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A05.10.20New Issue

KJ/EC IPP B06.02.10ECN773 dwg rev.D EC

IPP C 07.03.20 rev F dwg IPP D 07.03.28 re-format

EC

IPP E 07.10.31 ecn 1053P

EC EC

IPP Rev:F ECN 1056 07-11-13 DD

verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP

Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D2500-1-100	V. V. V.	Manufactured	No			100	Each	67.0000	1	1		
D2500-1-	100		······································	 -		e e u		-	**		&	440820
				Location	:	Loc	Oty	Loc Code				
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					86065		14 53				_	
D3389-1		Manufactured	No			140	Each	2.0000	1	1	_	
D3389-1	k								**			
Web											. //-	14-11-10
				Location	,	Loc		Loc Code			α	
				LG002	125/35		2 2		_	_(/)		
D3681-1		Manufactured	No			160	Each	65.0000	5	5	_	*-
*D3681-17	k								**		# + 2	BE 14-11-1
Spacer											Q	1901100 16
				<u>Location</u>	<u>1</u>	Loc		Loc Code			9	13990 V
				LG001	114884		65 57		_	<u>,,</u>		

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DQA:	Date: Date:										G "	ART					
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					DISPOSITION												
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					Rework			Skid-tube	Crosstube	\dashv	5	Water Jet	Engine	· -			
Part N	o				Scrap			Machining	Small Fab	\dashv		d. Eng. Coor.	—	uality			
NCD N	_				Use-as-is		Thern	noforming Large Fab	Finishing Composite	ᅴ	Rec/Stor	e/Packaging Supplier	_	Other			
NCR N	0				Suspected Unapproved			raige ran	Composite								
Root				Desci	ription of work order update	ı	Initial	Act	tion		Sign &						
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desci	ription	_	Date	Verification	QC I	nspector			
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Landin F	g Gear				General])		\Box	Outside Dim	ansions [Pressure	/Forced			
-	Bending				Bend	<u> </u>	Grain	Program	am -		Over/Under		Set-up	eri orceu			
ŀ	Centre No	ot Conce	ntric	-	BOM/Route Broken/Damage/Defect	\vdash	Hardwa			${f -}$	Part Incorre	<u> </u>	- - '	ature/Cure			
-	Cracks	mle/Dimmle	/\A/aa	\vdash	1 ' " '	-	4	ion Incomplete/U	ngualified	${f -}$	Part Lost/Mi		Weld	ature, cure			
	Crimp/Ki	nk/kippie	e/ wave	-	Burrs Contamination	\vdash	-i '	tions Incomplete/	•	╌	Part Moved	1331116	┥	Stock Pulled			
}	Crushing			<u> </u>	Countersink	\vdash	_	gned/off center	Official	\vdash	Positioned V	L Vrong					
}	Heat Trea			 	Cut Too Short	-	Mislab			-	Power Loss/		Other				
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-	Marks/Ch		ilube		Drill Holes	-	Off-set			•		· · · · · · · · · · · · · · · · · · ·		** * *			
	Turning S		1		Finish		-	Calibration		•		·					
-	→	•		-	Fit/Function		-	Sequence		•							
	Wave/Twist in Tube Fit/Function							•									

Picklist Print Thursday, August O	t 97, 2014 11:15:22 A	M										Pag	e 2
Work Order ID: 1	23429	<u> </u>	*1	234	29*					-			
Parent Item:	03391-023				1-023*	•							
Parent Item Name: Mid Tube Assembly				. 1. 1.	71-(77 ()			Start Date: 7/29/14 Start Qty: 1.00			Required Date: 8/07/14 Required Qty: 1.00		
D3591-1		Manufactured	No				Each	94.0000		2	٨	1	
D3591-	1							•	**		JIL	val (210	5
-				Locat	<u>ion</u>	L	oc Oty	Loc Code					
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					115645		4						
					92873		6						
				FP			84						
					115533		58			<u> </u>			
					121446		26		•				
ALS4-1032-130	AELS4-1032-130		No			230	Each	5,259.000	20	20	1	() (
AI S4-1	032-130							,	**		Ill	11/12/05	
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				ST26	7		5259					-	
					M126109		57						
					M128211		48						
					M128649		5154			<u> </u>	. 6		

DQA:		Date:			· WORK ORDER NON CONFORMANCE / HRRATE									
QA Closed:	WORK ORDER NON-CONFORMANCE / UPDATE sed: Date: Work Order update of											AEROSPACE		
	· · · · · · · · · · · · · · · · · · ·				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS			
Work Orde	r:					. 1				¬ '				
					Rework			Skid-tube	Crosstube		Water Jet	Engineering		
Part N	o				Scrap			Machining	Small Fab	_	d. Eng. Coor.	Quality		
NCD N		., ·			Use-as-is		Therr	moforming	Finishing Composite	- Rec/Stor	re/Packaging Supplier	Other		
NCR N	o				Suspected Unapproved	l		Large Fab	Composite	_i	Supplier_			
Root				Desc	ription of work order update		nitial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector		
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Landin F	g Gear				General	_	1	•	Г	Outside Dim	Г	Pressure/Forced		
}	Bendin	•		-	Bend	Folio/Program				Over/Under		Set-up		
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}	Cracks	via la /pia a l	- /\41	-	Broken/Damage/Defect	-	Hardwa		- Lauralified	Part Lost/M	<u> </u>	Weld		
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Heat Treat Inspection Strip in Tube					4	-	Misrea		L			0.1101		
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